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"Alaskan Clothing"

1914



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WAR DEPARTMENT : QUARTERMASTER CORPS

SPECIFICATIONS NO. 1171

FOR

ALASKAN CLOTHING



WASHINGTON
GOVERNMENT PRINTING OFFICE
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FEB. 14 1914

SPECIFICATIONS FOR ALASKAN CLOTHING.

[Adopted Jan. 14, 1914, in lieu of specifications Nos. 855, 856, 857, 858, 863, 864, 868, 928, 929, 950, and 977, which are canceled.]

BOOTS (RUBBER, SHORT).

To have heavy rubber sole and heel; rubber reinforced khaki vamp; rubber reinforced khaki leg; rubber reinforced seams. The inside to be net lined.

The height of size 8 is $15\frac{1}{2}$ inches from bottom of heel to top of leg at the back, other sizes to be of proportionate heights.

All sizes are to be width "W."

CAP (FUR).

Material.—Fur portion, consisting of the cape and a band not less than $2\frac{1}{2}$ inches wide, measured on the pelt, extending around the base of the crown of the cap; to be full furred, season trapped, muskrat skins, winter or spring skins only, thoroughly dressed with butter or oleomargarine, and cleaned with sawdust. No alum or vitriol or other chemicals to be used. To be repaired and made on a fur machine, and to be as well matched and with no more piecing than is shown in the standard sample.

Top of crown and cape lining to be of olive-drab satin, cotton back, of the quality and shade shown in the standard sample.

Lining of crown, 16-ounce sky blue kersey, Army standard.

Interlining of good quality French canvas.

Sweatband of black venetian cloth, not less than $1\frac{5}{8}$ inches wide.

Measurements.—Height of crown to be not less than 9 inches, cut full in the circular slant. The greatest depth of the earlaps to be not less than 8 inches continuing around the cap, forming in the back a cape of not less than 4 inches in depth.

Measurements to be taken from the seam joining the cape and the crown to the tip of the crown. Cape measurements to be taken on the lining of the completed cap.

Construction.—The satin crown to be in four pieces, stitched together and overstitched, with Army standard olive-drab "B" silk, so as to form a lap or welt seam.

To be stitched to the fur band by a fur machine.

The lining and interlining, extending to the bottom of the crown, are each in four pieces, stitched together by a flat open seam, with an extra row of stitching on either side of the seam.

The bottom of the fur band is stitched between the kersey lining and the cape lining.

The fur cape is stitched to the cape lining around the edge on a fur machine.

On the edge which joins the crown it is stitched to a tape, which in turn is stitched to the sweatband and the kersey lining. The sweatband is stitched on a light cotton wadding, with three rows of stitching, not less than 10 nor more than 20 stitches to the inch, and the upper edge is securely tacked to the crown lining.

To have a black tape at the top of each earlap not less than 9 inches long and $\frac{3}{8}$ of an inch wide, to hold the earlap in position over the crown of the cap, and to fasten under the chin. The earlaps are also to be provided with a button and loop to close them over the chin when the cape is drawn down; the nose protector to be made of two thicknesses of satin, like the crown of the cap, covered with muskrat fur on the outside; to be 2 inches wide and not less than $6\frac{1}{2}$ inches long, finished with a buttonhole at either end.

On the front edge of the cape, and about 2 inches from the crown of the cap, are placed two buttons to hold the nose protector in place, and a third button, $5\frac{1}{2}$ inches farther to the rear, and downward, on the right side of the cape, to secure the nose protector when not in use.

The buttons to be $\frac{7}{16}$ of an inch in diameter, covered with the same satin that is used on the crown.

The above measurements and description based on size $7\frac{1}{4}$; all other sizes to be in proportion.

Variations in sizes not to be less than $\frac{1}{8}$ of an inch for each size in the measurements given for size $7\frac{1}{4}$. Caps to be blocked to proper size.

GAUNTLETS (HORSEHIDE).

Leather.—*Palms and thumbs* to be made of chrome tan horsehide, frized finish, free from injurious scars, flank leather, and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Backs and gauntlet cuffs to be made of duck, piece dyed, of color shown in the standard sample, not less than 44 two-ply threads to the inch of warp, and not less than 30 two-ply threads to the inch of filling, strength test of not less than 95 pounds to the $\frac{1}{2}$ inch of warp and not less than 60 pounds to the $\frac{1}{2}$ inch of filling.

Gauntlet cuff facing to be made of bark tan sheepskin, grain finish, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Pattern.—To be as shown in the sealed standard sample, four fingers and thumb with gauntlet cuff, 5 inches deep and 7 inches across sleeve end of cuff.

Workmanship.—Gloves to be stitched around outside edge with one seam of No. 24 cotton thread, not less than 10 stitches to the inch, of uniform tension, and well drawn in; thumb to be secured to the palm and back with one seam around outside edge of the thumb with No. 24 cotton thread, not less than 10 stitches to the inch, of uniform tension, and well drawn in; the gauntlet cuff, palm, and back to be joined together and sewn on the gauntlet cuff facing and the hand of the gauntlet to be inserted between the two and sewn with two rows of No. 24 cotton, ornamented with cross stitch in red thread; the lower, or sleeve, edge of the gauntlet cuff to be bound with silesia binding and cotton thread to harmonize in color, with not less than seven stitches to the inch. Completed gauntlet to be smooth, neat, and of good appearance, and to weigh not less than $4\frac{1}{2}$ ounces to the pair.

The length of the gauntlet from the top of the hand to the wrist at the point where the cuff joins to be not less than—

	Inches.
In size 8.....	$8\frac{1}{4}$
In size $8\frac{1}{2}$	$8\frac{1}{4}$
In size 9.....	$8\frac{1}{4}$
In size 10.....	$8\frac{1}{2}$
In size 11.....	$8\frac{1}{2}$

The width of the hand at the point where the thumb seam starts from the back of the palm to be not less than—

	Inches.
In size 8.....	4
In size $8\frac{1}{2}$	4
In size 9.....	4
In size 10.....	$4\frac{1}{4}$
In size 11.....	$4\frac{1}{2}$

The width of the cuff when finished to be not less than $4\frac{1}{2}$ inches on all sizes.

The length of the entire gauntlet when finished to be—

	Inches.
In size 8 not less than.....	13
In size $8\frac{1}{2}$ not less than.....	$13\frac{1}{4}$
In size 9 not less than.....	$13\frac{1}{4}$
In size 10 not less than.....	$13\frac{1}{4}$
In size 11 not less than.....	$13\frac{1}{2}$

GLOVES (HORSEHIDE).

Leather.—*Palms and thumbs to be made of chrome-tan horsehide, frized finish, brown color, free from injurious scars, flank leather and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.*

Backs and bands to be made of chrome-tan cowhide, grain finish, brown color, free from injurious scars, flank leather and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Band facing to be made of bark-tan sheepskin, grain finish, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Pattern.—To be as shown in the sealed standard sample, four fingers and thumb, with band and band facing at wrist to furnish a proper finish and support a fastener. Thumb piece to be one continuous piece from top of thumb to edge of the wrist end of the glove (so as to allow the hand when incased in the woolen glove to slip easily into the thumb, and also to enable the glove to be bound over the wrist securely when on the hand).

Wrist fastening.—The wrist fastening to be brown string or cord about $5\frac{1}{2}$ or 6 inches long extending across the wrist end of the thumb from one edge of the band and facing to the other edge, and so placed that it can be drawn taut and wound around a spring button stud at the opposite edge of the band facing from where the string originates.

Workmanship.—Gloves to be stitched around outside edge with one seam of No. 30 linen thread, well waxed, not less than eight stitches to the inch, of uniform tension, and well drawn in. A white piping or welt to be inserted in the seam between the edges of

the back and front forming a protection for the said stitching; thumb to be secured to the palm, back and band, and band facing with one seam around the outside edge of the thumb with No. 30 linen thread, well waxed, not less than eight stitches to the inch, of uniform tension and well drawn in. A white piping or welt to be inserted in the seam between the edges of the thumb and the palm, back and band facing of the glove, forming a protection for the said stitching. The wrist edge of the thumb to have no stitching whatever on it. The band facing to be felled on the band at the wrist edge with No. 24 cotton thread and laid under the palm and back of the glove at the wrist edge of the said palm and back and sewn to said palm and back at that edge, forming an inside finish and stiffening to the band. The band to be laid on and sewn to the wrist edge of the palm and back of said glove with No. 24 cotton thread, forming a finish and a support for a wrist fastening, ornamented on the back with three rows of four-needle stitching, starting at the wrist end of the back of the glove, and extending about $3\frac{1}{2}$ inches toward the fingers, the two outside rows being farther apart at the finger ends of the stitching than at the wrist end of the stitching; the stitching to be in No. 40 red cotton thread; ornamented also across the seam which joins the band to the glove with a row of overstitch embroidery done in No. 24 red cotton thread, this last also serving as a finish to the seam. Completed glove to be smooth, neat, of good appearance, and to weigh not less than 6 ounces to the pair.

Measurements.—The length of the glove from the top of the hand to the wrist at the point where the band joins to be not less than $8\frac{3}{4}$ inches. The width of the hand at the point where the thumb seam starts from the back to the palm to be not less than 5 inches. The width of the wrist band when finished to be not less than $1\frac{1}{2}$ inches. The length of the entire glove to be not less than $10\frac{1}{4}$ inches when finished.

GLOVES (SCOTCH WOOL).

Description.—To be what is known as thoroughly seamless machine-knit wool gloves, free from imperfections in manufacture. Material to be a long-staple Scotch wool of grade not lower than one-half blood. The cuff to be knitted from $3\frac{1}{2}$ to 4 inches long, of a one and one rib and to be about 4 inches in diameter at top, and to have a welt on the upper edge to prevent raveling.

The hand.—After the cuff has been transferred stitch by stitch (without any seam) on the machine, producing a plain seamless fabric, the hand shall be knitted to proper size from 4 to $4\frac{1}{2}$ inches in length according to size of glove to be produced, leaving an open space for the insertion of the thumb. The thumb to be knitted at the same time as the glove. The thumb to be 4 inches long. The fingers to be knitted seamless and of proper graduated length, overlapping each other to give proper fit to the human hand.

Sizes.—To be of three sizes, No. 9, No. 10, and No. 11, measuring, when finished, as follows: No. 9 to be not less than $9\frac{1}{2}$ inches in length from the tip of the middle finger to top of cuff. No. 10 to be not less than 10 inches and No. 11 to be not less than $10\frac{1}{2}$ inches. Each size to have its proportionate width, and to weigh between 4 and $4\frac{1}{2}$ pounds to the dozen.

Color.—To be olive drab.

HAT (SOU'WESTER).

Squam design, made from best quality sheeting material weighing $3\frac{1}{2}$ yards to the pound, 36 inches wide; lined with canton flannel, cap lap coming under chin; color green; four sizes: $6\frac{3}{4}$, 7, $7\frac{1}{4}$, and $7\frac{1}{2}$.

HEADNET (BOBINET).

To be made of green bobinet with green muslin crown; edges to be bound with tape. Strings of tape and loops attached, so as to allow net to be held down.

INSOLES (FELT).

To be half inch in thickness, gray heavy wool felt made in three sizes—small, medium, and large.

MITTENS (DUCK).

Backs, thumbs, and bands.—Duck, piece dyed, of color shown in standard sample, not less than 44 two-ply threads to the inch of warp, and not less than 30 two-ply threads to the inch of filling; strength test of not less than 95 pounds to the $\frac{1}{2}$ inch of warp, and not less than 60 pounds to the $\frac{1}{2}$ inch of filling.

Band facing to be made of bark-tan sheepskin, grain finish, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Pattern.—To be as shown in the sealed standard sample, round at finger ends, with band and band facing at wrist to furnish a proper finish and support a fastener; thumb piece to be one continuous piece from the top of the thumb to the edge of the wrist end of the mitten to enable the mitten to be bound securely over the wrist when on the hand.

Wrist fastening.—The wrist fastener to be brown string or cord about $5\frac{1}{2}$ or 6 inches long extending across the wrist end of the thumb from one edge of the band and facing to the other edge, and so placed that it can be drawn taut and wound around a spring button stud at the opposite edge of the band facing from where the string originates.

Workmanship.—Mitten to be stitched around outside edge with one seam of No. 24 cotton thread, not less than 14 stitches to the inch, of uniform tension and well drawn in; thumb to be secured to the palm and back band and band facing with one seam around outside edge of the thumb with No. 24 cotton thread, not less than 14 stitches to the inch, of uniform tension and well drawn in; the wrist edge of the thumb to have no stitching whatever; the band facing to be felled on the band at the wrist edge with No. 24 cotton thread, and laid under the palm and back of the mitten at the wrist edge of the said palm and back and sewn to said palm and back at the edge, forming an inside finish and stiffening to the band; the band to be laid on and sewn to the wrist edge of the palm and back of said mitten with No. 24 cotton thread, ornamented with a row of cross stitches in thread to harmonize, forming a finish and a support for a wrist fastener. Completed mitten to be neat and of good appearance.

The length of the mitten from the top of the hand to the wrist at the point where the band joins to be—

	Inches.
In size 10 not less than.....	$8\frac{1}{4}$
In size 11 not less than.....	$8\frac{1}{2}$
In size 12 not less than.....	$8\frac{3}{4}$

The width of the hand at the point where the thumb seam starts from the back of the palm to be—

	Inches.
In size 10 not less than.....	$4\frac{1}{2}$
In size 11 not less than.....	$4\frac{1}{2}$
In size 12 not less than.....	$4\frac{3}{4}$

The length of the entire mitten when finished—

	Inches.
In size 10 not less than.....	$9\frac{3}{4}$
In size 11 not less than.....	10
In size 12 not less than.....	$10\frac{1}{4}$

The width of the wristband when finished to be in each size not less than $1\frac{1}{2}$ inches.

MITTENS (FUR).

To be made from bear, dog, or wolf skin, with a long gauntlet cuff; palm to be of either leather, with or without fur; to be woolen-blanket lined, which is to be fastened only at outer edge of gauntlet cuff, so lining can be pulled out to dry. These should be made very large, so woolen mittens can be worn inside, and with heavy neck and breast cords attached.

MITTENS (HORSEHIDE).

Leather.—Palms and thumbs to be made of chrome tan horsehide, frized finish, brown color, free from injurious scars, flank leather and creases, to be made as smooth and nearly equal thickness throughout as can be obtained commercially.

Backs and bands to be made of chrome tan cowhide, grain finish, brown color, free from injurious scars, flank leather, and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Band facing to be made of bark-tan sheepskin, grain finish, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Pattern.—To be as shown in the sealed standard sample, round at finger ends, with band and band facing at wrists to furnish a proper finish and support a fastener; thumb piece to be one continuous piece from top of the thumb to the edge of the wrist end of the mitten, so as to allow the hand when incased in a woolen glove to slip easily into the thumb and also to enable the mitten to be bound over the wrist securely when on the hand.

Wrist fastening.—The wrist fastening to be brown string or cord about $5\frac{1}{2}$ or 6 inches long extending across the wrist end of the thumb from one edge of the band and facing to the other edge and so placed that it can be drawn taut and wound around a spring button stud at the opposite edge of the band facing from where the string originates.

Workmanship.—Mittens to be stitched around outside edge with one seam, of No. 30 linen thread, well waxed, not less than eight stitches to the inch, of uniform tension and well drawn in; a brown piping or welt to be inserted in the seam between the edges of the back and front forming a protection for said stitching; thumb to be secured to the palm, back and band and band facing with one seam around the outside edge of the thumb, with No. 30 linen thread well waxed, not less than eight stitches to the inch, of uniform tension and well drawn in; a brown piping or welt to be inserted in the seam between the edges of the thumb and the palm, back and band facing of the mitten, forming a protection to said stitching; the wrist edge of the thumb to have no stitching whatever on it; the band facing to be felled on the band at the wrist edge with No. 24 cotton thread and laid under the palm and back of the mitten at the wrist edge of the said palm and back and sewn on said palm and back at the edge, forming an inside finish and stiffening to the band; the band to be laid on and sewn to the wrist edge of the palm and back of the said mitten with No. 24 cotton thread, forming a finish and a support for a wrist fastener. Completed mitten to be smooth, neat, of good appearance, and to weigh not less than 6 ounces to the pair.

Measurements.—The length of the mitten from the top of the hand to the wrist at the point where the band joins to be not less than 9 inches. The width of the hand at the point where the thumb seam starts from the back to the palm to be not less than $4\frac{3}{4}$ inches. The width of the wristband when finished to be not less than $1\frac{1}{2}$ inches. The length of the entire mitten to be not less than $10\frac{1}{2}$ inches when finished.

MITTENS (SIWASH).

Leather.—*Palms, thumbs, and backs of hand* of the mitten to be made of chrome tan horsehide, frized finish, brown color, free from injurious scars, flank leather, and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Palms of gauntlet cuffs to be chrome tan cowhide, grain finish, brown color, free from injurious scars, flank leather, and creases, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Backs of gauntlet cuffs to be made of hair seal, well tanned and free from injurious scars and hair slips, to be as nearly equal thickness throughout as can be obtained commercially.

Gauntlet cuff facing to be made of bark tan sheepskin, grain finish, to be as smooth and nearly equal thickness throughout as can be obtained commercially.

Lining.—Both mitt and gauntlet cuff to be lined with navy blue Mackinaw cloth, counting not less than 30 threads to the inch of warp and not less than 36 threads to the inch of filling, standing a tensile strain of not less than 50 pounds to the inch of warp and not less than 60 pounds to the inch of filling; weighing not less than 24 ounces to the yard (36 inches wide); to be thoroughly gigged on both sides.

Workmanship.—Mittens to be stitched around outside edge with one seam of No. 30 linen thread, well waxed, not less than eight stitches to the inch, of uniform tension and well drawn in. A brown piping or welt to be inserted in the seam between edge of the back and front,

forming a protection for said stitching; thumb to be secured to the palm and back with one seam around outside edges of the thumb, with No. 30 linen thread, well waxed, not less than eight stitches to the inch; a brown piping or welt to be inserted in the seam between the edges of the thumb and palm and back, forming a protection for said stitching. The gauntlet cuff, back, and palm to be sewn to the gauntlet cuff facing. The mitt palm and thumb to be inserted between the palm and back of the gauntlet cuff, which form the outside of the gauntlet cuff when finished, and the gauntlet cuff facing which forms the inside finish of the cuff, and sewn with No. 24 brown cotton thread and set inside of the mitt, making a lining running from the ends of the fingers to the sleeve end of the gauntlet. The sleeve ends of the palm and back of the gauntlet cuff and palm and back of the lining to be bound together with brown kid binding, sewn with No. 36 brown cotton thread. The lining to be no way connected with the leather gauntlet mitten, at the tops of the fingers, as shown in the standard sample. Completed mitten to be smooth, neat and of good appearance, and to weigh not less than 19 ounces to the pair.

Measurements.—The length of the mitten from the top of the hand to the wrist at the point where the cuff joins to be not less than $8\frac{3}{4}$ inches. The width of the hand at the point where the thumb seam starts from the back to the palm to be not less than 5 inches. The width of the cuff when finished to be not less than $6\frac{3}{4}$ inches. The length of the entire mitten to be not less than 15 inches when finished.

MOCCASINS (MOOSE HIDE).

Pattern.—All moccasins to be of the cut and style shown in the sealed standard sample.

Leather.—For all parts the leather to be the best oil-tanned moose hide, free of lime or other injurious substances. No flanky, scarred, or defective leather to be used. The leather for the foot must be one perfect piece $\frac{1}{8}$ inch thick, solid, smooth, and firm to the touch. The toe covering must be of the same quality and thickness. The leather for the ankle will be cut in five pieces, smooth and firm to the touch, of about $\frac{1}{16}$ inch thickness, each piece of each pair being carefully selected with regard to uniformity of density, thickness, firmness, and color.

Cutting.—The leather must be cut clean, straight, and smooth. The toe cover and foot should be brought edge to edge and sewed on the outside with a lock stitch running diagonally through the leather, the needle entering about $\frac{1}{8}$ inch from the outer edge and coming out above the inner edge, leaving a firm welt on the outside and a smooth matched surface on the inside. The ankle pieces will be shaped so that the tongue will fold in smoothly without wrinkles, making a smooth, easy, comfortable fit. The back of the two ankle pieces will be sewn with a straight through-and-through seam, the two sides drawn out straight and smooth and the backstay attached on the outside with two seams $\frac{1}{8}$ inch apart around the entire edge of the space. The tongue leather shall be shaped in two parts to form a facing for the front of the ankle leather, to which it shall be sewed with two seams $\frac{1}{2}$ inch apart, forming a lacing stay to support the eyelets.

Stitching.—Ankle leather to be stitched to foot with two rows of No. 24 cotton thread, lock stitched, not less than 10 stitches to the inch; rows to be $\frac{1}{8}$ inch apart, and in addition to be secured at the lacing ends with a heavy brass staple rivet clinched on the inside. Tongue leather to be sewn across toe cover with two rows of No. 28 cotton thread, lock stitch, not less than 10 stitches to the inch. The inner sides of tongue to be joined with through-and-through lock-stitched seam, not less than 10 stiches to the inch, No. 28 cotton thread, seam to be run $\frac{1}{8}$ inch from the edges, and edges pressed out to form a flat surface inside ankle of moccasin. The seam uniting toe covering to foot and the heel forming seam shall be of No. 20 well waxed linen thread.

Fastenings.—There shall be 14 eyelets in each moccasin, 7 each side, eyelets to be $\frac{9}{16}$ inch outside diameter and $\frac{5}{16}$ inch diameter of hole, made of stock equal in all respects to sample, and shall be set with a die and eyelet punch, and each one shall be drawn snug, setting well down on, but not cutting into the leather. There shall be furnished with each moccasin one buck or moose-hide string; this string to be not less than 4 feet in length, of not less than $\frac{1}{8}$ inch stock, and may be cut from a circle.

Finishing.—The finished moccasin shall present a smooth, neat, and good appearance, and weigh not less than 15 ounces, including strings, to the pair. Material shall be of the best quality. Workmanship neat, strong, and durable.

MUCKLUCKS (WATER BOOTS).

Tops to be made from hair seal, tanned, with hair removed and thoroughly oiled. Bottoms to be of loose tack sole made from walrus or hair sealskin. They should be long enough to come above the knee.

MUCKLUCKS (WINTER BOOTS).

Tops to be made from hair seal, tanned, with hair left on, unoiled, the boots made with hair on inside. Bottoms to be of loose tack sole made from walrus or hair seal. To be long enough to reach well above the knee.

OVERCOAT (FUR).

Buffalo overcoat as issued.

PARKA (DUCK).

Materials.—Duck, piece dyed, of color shown in standard sample, not less than 44 two-ply threads to the inch of warp and not less than 30 two-ply threads to the inch of filling, strength test of not less than 95 pounds to the $\frac{1}{2}$ inch of warp, and not less than 60 pounds to the $\frac{1}{2}$ inch of filling.

Thread, best cotton, Nos. 24 to 30, J. & P. Coates or equal.

Pockets.—To have a pocket on front divided into two compartments.

Buttonholes.—Six buttonholes securely worked by hand or machine; two in hood where joined to neck to allow tightening cord to pass

through, and two at cuff on each sleeve to allow tightening braid to pass through.

Cord.—To have a cord of $\frac{1}{4}$ -inch diameter, twisted, not less than 40 inches long, securely fastened at center of hood where joined to body.

Braid.—To have a piece of braid $\frac{5}{8}$ inch wide in each sleeve not less than 30 inches long, and securely fastened in center of cuff.

PARKA (FUR TRIMMED).

To conform in all respects to the specifications for parka (duck), except that the front of hood and bottom of sleeve will be finished with wolf, wolverine, or lynx fur; the edges of skin must be turned in and must be 2 inches in width when finished.

PARKA (FUR).

To be of knee length, made of reindeer summer skin, or squirrel skin, tanned, lined with some suitable material that will allow it to slip on easy. To be made full, especially around armholes, enabling one to withdraw arms from sleeve without taking parka off; to have a large hood with wolverine or wolf fur ruff around edge of hood; cuffs to be edged with same fur. Minimum length should not be less than 42 inches from neckband to bottom.

PEA-JACKET (KERSEY LINED).

Materials.—Duck, piece dyed, of color shown in standard sample, not less than 44 two-ply threads to the inch of warp, and not less than 30 two-ply threads to the inch of filling, strength test of not less than 95 pounds to the $\frac{1}{2}$ inch of warp, and not less than 60 pounds to the $\frac{1}{2}$ inch of filling. Army standard sky-blue kersey, 16-ounce. Canton flannel a dark-brown color with strength test of not less than 80 pounds to the inch of warp and not less than 30 pounds to the inch of filling.

Thread, best cotton, Nos. 24 to 30, J. & P. Coates or equal.

U. S. Army standard bronze buttons.

Best vegetable ivory buttons.

Pattern.—Double-breasted pea-jacket. Of cut shown in the standard sample.

Collar.—To be full roll, not less than $6\frac{3}{4}$ inches wide, not less than 26 inches long at bottom, and not less than 32 inches at top, based on a size No. 3. Others in proportion. To be closed in front with a 45-ligne black vegetable ivory button and frog loop of $\frac{3}{8}$ -inch black cord. Kersey to be properly quilted. To have a canvas hanger.

Pockets.—To have four pockets of canton flannel, two with horizontal openings, faced with duck, and not less than 7 inches wide and 8 inches deep, covered by flaps, lined and faced with S. B. kersey, not less than 4 inches wide and of sufficient length to cover pocket; two slanting pockets with 7-inch openings, extreme depth not less than 12 inches, faced with kersey. Top of slanting pockets to be on a line with the third button from the top, and horizontal pockets about on a line with the bottom buttons.

Lining.—To be of two thicknesses of kersey, quilted in $3\frac{1}{2}$ -inch squares and joined to body of garment without puckering; to be turned so as to make a piping $\frac{3}{8}$ inch wide all around edges.

Seams and stitching.—An allowance of $\frac{3}{8}$ inch to be made for all seams, to be welt and double stitched. Two rows of stitching from $\frac{1}{4}$ inch to $\frac{1}{2}$ inch apart around all edges, and $\frac{3}{4}$ inch along the line of buttons, thus forming button stays.

Buttonholes.—To have five on each front, properly spaced, to be neatly worked by machine or hand, and securely bar-tacked by separate operation.

Buttons.—Five coat, large, bronze, on each front and one 45-ligne black, vegetable ivory on collar, properly placed and securely sewed on.

Workmanship.—The garment to be clean, well made, and pressed in a workmanlike manner. No raw edges to show.

Sizes.—To be made in six sizes. Each garment to be provided with a ticket showing size and breast measurement; sizes and measurements to be as follows:

Sizes.	Breast measure.	Length.	Length of sleeve.
	Inches.	Inches.	Inches.
1.....	36	32	$31\frac{1}{2}$
2.....	38	33	$32\frac{1}{2}$
3.....	40	34	$33\frac{1}{2}$
4.....	42	35	34
5.....	44	36	$34\frac{1}{2}$
6.....	46	37	35

The breast measurements in the above table are the actual measurements taken of men with coats off. In order that the garments be of proper size to fit the persons so measured and to conform to the style of standard samples, the coats when finished should measure 13 inches larger in the breast from edge to edge.

ROBE (WOLFSKIN).

To be made of tanned wolfskin $6\frac{1}{2}$ by $7\frac{1}{2}$ feet long; to be blanket lined. The blanket and skin to be thoroughly tacked together. Robes to be numbered; stamped "Q. M. Corps."

SHOES (FELT).

Upper.—To be made of 28-ounce felt dyed black. Vamp cut in one piece. Quarter also of 28-ounce felt, cut in two pieces, one for each side, in such manner that the edges will unite at median line and lay smoothly side by side the length of the vamp, these edges to be securely overhanded with No. 24 black cotton thread, to make a perfectly smooth flat seam. At point where lace opening begins will be placed a piece of black sheepskin of sufficient size to serve as a reinforcement, this piece to lay smoothly between the vamp and quarter and be stitched in the same seam that holds vamp and quarter together. Heel of quarter to be shaped so as to lie smoothly and evenly over counter and cross-stitched both ways with No. 30

black cotton thread, forming a smooth and perfect union. Both vamp and quarter running through to bottom of last.

Lining.—Shoe to be lined throughout with 16-ounce felt, dyed red. Lining to be cut in two pieces; to lap at least $\frac{1}{2}$ inch where it joins. Back part to be shaped same as quarter and sewn through and through with No. 30 cotton, the raw edge on the outside next to seam of quarter, leaving the inside of shoe smooth and well finished. Vamp to be lined with best white drill, monogram brand or equal, counting not less than 66 threads to the inch of warp, and not less than 42 to the inch of filling, and to have a tensile strength of not less than 100 pounds to the inch of warp, and not less than 90 pounds to the inch of filling. Vamp lining to be placed between black and red felt, extending from under toe and back to shank. Drill interlining to be cut in two pieces, fitted smoothly, and securely stitched where joined. Vamp, quarters, interlining and lining, all to be lasted under together at heel and toe at least $\frac{3}{4}$ inch.

Staying.—Inside lace stay to be of good quality black sheepskin, to extend from top of quarter to at least $\frac{3}{8}$ inch under vamp; to have four studs and six eyelets on each side, of brass, black japanned, properly spaced. Top facing to be of good quality russet sheepskin. Back stay to be of good quality black kid, not less than $1\frac{3}{4}$ inches wide at vamp, and not less than $\frac{1}{2}$ inch wide at top. Pull strap to be of extra-heavy tubular webbing lasted under at the heel, doubled at top, forming loop not less than 2 inches in length.

Counter.—To be not less than 8 inches long, formed of heavy fiber board between two thicknesses of split leather, extending well under sole and firmly cemented between lining and quarters.

Soles.—Outer sole to be made of $\frac{3}{8}$ -inch sole felt, weighing about $\frac{1}{2}$ pound per pair; insole of solid well-tanned plump side leather, weighing not less than 10 ounces to the square foot. Bottom filling to be of gray felt, well cemented in place. Sole to be supported at the shank by a piece of properly curved spring steel not less than $\frac{1}{2}$ inch wide, $\frac{1}{32}$ -inch thick, resting on a piece of fiber board which fills in the shank space, and extending well under heel, where it is secured by a $\frac{1}{8}$ holdfast clinching nail. Outsoles to be McKay sewed with channel, grooved not less than one-third the thickness of the sole. Eight-cord linen thread of best quality to be used in stitching outsoles, with not less than 4 stitches to the inch. Sock lining of 16-ounce felt, dyed red, securely cemented down over the entire inner sole, the toe and edges to be perfectly smooth and without wrinkles.

Heel.—To be of same material as outsole one and one-half lifts high or not less than $\frac{1}{2}$ inch; to weigh not less than $\frac{1}{8}$ pound per pair on an average, not less than 10 holdfast clinching nails, size $\frac{1}{8}$, put into each heel and clinched.

Stitching.—Vamp to be stitched to quarter and through interlining and lining with two seams $\frac{1}{8}$ inch apart, not less than 10 stitches to the inch. Stitching to be done on lock-stitch machine, using No. 30 black cotton on the outside and No. 36 red cotton on the inside. Lacing stay to be stitched with one seam on each edge, lock-stitch, with No. 30 black cotton both sides. Facing leather to be stitched to lining on inner edge and through quarter on outer edge with lock stitch, using No. 30 black cotton on outside and No. 30 white cotton on inside. Back stay to be stitched on each edge through quarter only and through top lining, and both thicknesses of pull strap at

top, seam to run down, forming a V, $\frac{1}{2}$ inch deep and extending from side to side of strap to fasten the loop securely. Stitching to be lock, No. 30 black cotton both sides. Seam of vamp at back of counter to be pressed and stitched on each side, stitching to be lock, No. 30 black cotton. Vamp to be smoothly and neatly fitted over quarter and securely cemented over counter and quarter at heel.

Tongue.—Tongue to be made of 22-ounce felt, dyed black, of sufficient width to extend well out on each side of lace eyelet and stitched in with the same seam which holds vamp, quarter, and linings together. Each shoe to be provided with one 34-inch lace of good quality.

To be made of regular commercial sizes for felt shoes.

Length and width of shoes to be plainly marked on lining near top.

SHOE PACS.

Leather uppers.—To be cut from H. H. weight black kangaroo side leather; bellow tongues to be cut from same stock, split to proper weight and reaching to within half inch of top of the upper and to the edge on each side of the upper.

Sizes 5 to 7 to be made with 11 giant nickel eyelets on each side; sizes 8 to 12 to be made with 12 giant nickel eyelets on each side.

Height on size 8 to measure 12 inches from a point midway between toe and heel on the upper side of rubber foot; other heights on uppers on sizes to be graded in proportion.

To be made with an outside leather back strap and with a leather pull strap. The back strap is to be stitched with 4-cord No. 16 black cotton thread—two rows on each side and a V at the top.

The tongue to be stitched to the quarter with two rows of four cord No. 24 black cotton thread—one row on each side of the eyelet.

A strip of $\frac{5}{8}$ -inch bias cotton stay to be cemented on the inside at the top of the rubber foot and the leather uppers to be stitched from the outside to and through the top of the rubber foot and cotton stay with three rows of four cord No. 16 black cotton thread—the two lower rows of stitching to be close stitched and the upper row of stitching to be spaced.

The shoe pacs to have 72-inch rawhide laces.

Rubber feet—

Weight.—The weight of this rubber shoe is to be not less than 2 pounds $6\frac{1}{2}$ ounces, and not more than 2 pounds $8\frac{1}{2}$ ounces per pair size 9, width F.

Height.—The height of this shoe size 9 inside heel to be not less than $3\frac{2}{10}$ inches. Height size 9 vamp measured with dividers outside not less than $4\frac{6}{10}$ inches.

Lining.—A double thread net tan colored to run about 1.8 pounds per square yard and coated with a good quality compound on one side.

Insole.—Osnaburg with a friction coating on one side and on this a special quality rag, the whole to be 0.036 inch in thickness.

Vamp.—The vamp to be covered with a so-called vamp lining of osnaburg coated on both sides with a good friction compound.

Heel piece.—The heel piece of the same material to extend around the heel.

Binding.—The binding of the same material to extend around the top of the shoe.

Stay piece.—A stay piece on each side of the shoe from the top of the shoe down under the outsole, this to be $1\frac{1}{2}$ inches wide, to be of sheeting, about 5 yards to the pound, with a friction coating on both sides and also a good compound on one side to 0.020 inch in thickness.

Counter.—A counter 0.040 inch in thickness to be of sheeting about 7 yards to the pound, with a friction coating on one side and a special quality rag.

Rag shank.—Rag shank out of a special quality rag, 0.036 inch in thickness to extend from the shank to the end of the heel.

Outfiller.—Outfiller 0.050 inch in thickness to be of sheeting, about 7 yards to the pound, with a friction coating on one side and a special quality rag.

Upper.—The outside covering or upper to be 0.050 inch in thickness and of a compound containing not less than 41 per cent fine Para and Ceylon fine and 10 per cent coarse rubber, 51 per cent in all.

Ribs.—Five so-called ribs to extend from front opening to the edge of last at the toe. These to be of good compound and 0.025 inch in thickness.

Sole form.—The bottom to consist of a so called sole form of osnaburg with a friction coating on both sides.

Tap.—A tap under fore-part of outsole 0.065 inch in thickness and of a good quality compound.

Outsole.—An outsole 0.135 inch at the ball and 0.080 inch at the heel to be of a dark red compound containing not less than 37 per cent fine Para and Ceylon fine and 9.5 per cent coarse rubber, 46.5 per cent in all.

Heel.—A heel weighing about 0.51 pounds to a pair to be attached to this.

SKIIS.

Regulation commercial pattern as issued.

SLED TENT COVER.

To be made of nine widths of 27-inch Army standard duck cut 12 feet long, with box formed 36 by 18 inches; 21 inches from lower left-hand side of box the duck extends back 12 inches to the open end which is closed by a draw rope; the opening finishes 130 inches; 4-inch hem to be allowed for draw rope, which is made of $\frac{1}{2}$ -inch manila rope, 15 feet long with ends well whipped. Front end entirely closed; all seams should have two rows of stitches, and all edges turned in. The thread used may be linen or cotton, not less than No. 80 or No. 24, respectively. The sewing must be done on a lock-stitch machine, stitches to be not less than 12 to the inch.

Ten snaps to be securely fastened to clove by loops made of same material as cover.

Single snap at each lower corner of box and one single snap on each side of box, 20 inches from lower corner; single snaps on each side of bottom of cover, 5 feet, 9 feet, and 10 feet from lower corners of box; snaps to parallel 19 inches apart.

Snaps to be $\frac{3}{8}$ swivel, galvanized; cut in cover to finish 11 feet.

SLICKER (OILSKIN).

To be a double one-seamed coat, 44 inches long, with outside storm lap 24 by $4\frac{1}{2}$ inches, two outside stayed pockets $8\frac{1}{2}$ by $8\frac{1}{2}$ with pocket laps, 6-inch collar and throat piece faced with dark corduroy, eight 36-ligne wooden buttons for fastening coat, four on each front, sewed to sheepskin stays; three 27-ligne wooden buttons, two on right collar and one on left for fastening throat piece; three additional leather stays on lap for button holes; sleeves to be fitted with 7-inch inner sleeves with elastic and red flannel at wrist; garment to be made of best quality sheeting weighing $3\frac{1}{2}$ yards to a pound, 36 inches wide, lined with the same material; garments to be thoroughly oiled and cured. Color green.

Sizes	0	1	2	3
Inches	56	54	52	50

SNOW SHOES.

Regulation commercial pattern as issued.

SOCKS (ROPE).

To be made of best quality standard Escaba manila hemp, hand cleaned; entire sock to be made seamless and with an unraveling stitch. To be of sizes 10, 11, and 12 and to weigh about 5 pounds per dozen.

SOCKS (GERMAN).

To be a two-thread wool, seamless, well shrunk and tufted, and to have a strap of cotton belting well fastened to the sock around the top, and with buckle attached.

Color to be olive drab like standard sample.

Sizes No. 9, No. 10, No. 11, and No. 12.

Weight size 9 to be about 11 pounds to the dozen. Size 10 about $11\frac{1}{2}$ pounds to the dozen; size 11 about 12 pounds to the dozen, and size 12 about $12\frac{1}{2}$ pounds to the dozen.

SWEATER (WORSTED).

Material.—To be fleece, scoured or pulled wool of not lower grade than three-eighths blood, free from shives, burrs, kemp, shoddy, flocks, and other impurities.

Construction.—The wool to be smoothly carded and evenly spun. Color to be of an olive drab shade.

Workmanship.—To be knit on full fashioned sweater machines with what is known as 1/1 fine wale stitch.

The skirt to have a double-knitted border and to be about $2\frac{1}{4}$ inches deep.

The collar to be made nine ribs to the inch and to be threefold, of a height of about $3\frac{1}{2}$ inches when folded.

Weights and sizes.

	No. 34.	No. 36.	No. 40.	No. 44.
Length.....	inches..	25	26	27
Weight per dozen.....	pounds..	17	18	20

Measurements and weights to be approximately as above.

TOQUE (WORSTED).

To be of all worsted, double, two-thread yarn, cardigan rib, to measure 12 inches from bottom to crown when lying flat, unstretched; 1-inch tassel button on crown. Color to be olive drab.

TROUSERS (DUCK).

Materials.—Duck, piece dyed, of color shown in standard sample, not less than 44 two-ply threads to the inch of warp, and not less than 30 two-ply threads to inch of filling; strength test not less than 95 pounds to the $\frac{1}{2}$ inch of warp and not less than 60 pounds to the $\frac{1}{2}$ inch of filling.

White drilling, counting not less than 70 threads to the inch of warp and not less than 46 threads to the inch of filling.

Thread, best cotton, No. 24-30, J. & P. Coates, or equal.

Vegetable ivory buttons, four holes.

Pattern.—To be of cut shown in the standard sample.

Waistband.—Of duck with top pocket stays cut on, doubled and stitched.

Pockets.—To have five pockets of drilling, one watch pocket, two straight or top pockets, and two hip pockets. Faced, stitched, and stayed, of width and depth shown, and to be properly placed.

Flies and fly linings.—Of duck, stitched, barred, and tacked between buttonholes.

Buttons.—Six suspender and 1 waistband buttons, not less than 30 ligne, properly placed. Four fly buttons, not less than 24 ligne. To be securely sewn on and wrapped.

Buttonholes.—Four buttonholes, 1 in waistband and 4 in the fly. Neatly and strongly worked by machine or hand.

Buckle straps.—Of two thicknesses of duck, stitched and let in at the gores.

Belt straps.—Six belt straps of two thicknesses of duck, $2\frac{3}{4}$ inches long and $\frac{1}{2}$ inch wide, securely stitched and properly placed.

Buckle.—Of design, quality, and size shown in the standard sample.

Turn-up.—Not less than $\frac{1}{2}$ inch.

Seams and stitching.—Seat seams and waistband seams to be lapped and double stitched. Gore, outseams, and inseams single stitched and pressed flat.

Workmanship.—The garment to be clean, well made, and pressed in a workmanlike manner.

Sizes.—To be made in six sizes, each garment to be provided with a ticket showing size, waist, and inseam measurements. Sizes and schedule of measurements as follows:

Sizes.	Waist.	Seat.	Inseam.	Outseam.	Bottom.
	Inches.	Inches.	Inches.	Inches.	Inches.
1.....	32	45	30 $\frac{1}{2}$	40 $\frac{1}{2}$	20
2.....	34	47	30 $\frac{1}{2}$	41 $\frac{1}{2}$	20
3.....	36	49	31 $\frac{1}{2}$	42 $\frac{1}{2}$	20 $\frac{1}{2}$
4.....	38	51	32 $\frac{1}{2}$	43 $\frac{1}{2}$	20 $\frac{1}{2}$
5.....	40	53	32	43	21
6.....	42	55	32	44	21

UNDERDRAWERS (WOOL, KNIT).

Material.—Yarn to be composed of a mixture of not less than 76 per cent of wool and not more than 24 per cent of cotton; the wool to be half-blood fleece, scoured or pulled, to which shall be added a sufficient quantity of three-quarter blood natural black "tops" to produce the shade shown in the standard sample.

The cotton to be of a grade not inferior to "middling fair." The mixture to be free from shives, burrs, kemp, shoddy, and flocks. To be made on full fashioned machinery throughout.

Finish.—To be made normal with lap across abdomen as shown by standard sample.

Lining, inside waistband with specially prepared material as shown on standard sample.

Measurements.

Sizes.	Waist.	Seat.	Entire length.	Weight. ¹
	Inches.	Inches.	Inches.	
1.....	32	42	40 $\frac{1}{2}$	11 $\frac{1}{4}$
2.....	34	43	41	11 $\frac{3}{4}$
3.....	36	44	41 $\frac{1}{2}$	12 $\frac{1}{4}$
4.....	38	44 $\frac{1}{2}$	42	12 $\frac{3}{4}$
5.....	40	45	42	13 $\frac{1}{4}$
6.....	42	46	42	13 $\frac{3}{4}$
7.....	44	47 $\frac{1}{2}$	43	14 $\frac{1}{4}$

¹ Pounds per dozen.

Measurements and weights to be approximately as above.

UNDERSHIRT (WOOL, KNIT).

Material.—Yarn to be composed of a mixture of not less than 76 per cent of wool and not more than 24 per cent of cotton; the wool to be half-blood fleece, scoured or pulled, to which shall be added a sufficient quantity of three-quarter blood natural black "tops" to produce the shade shown in the standard sample.

The cotton to be of a grade not inferior to "middling fair." The mixture to be free from shives, burrs, kemp, shoddy, and flocks. To be made on full-fashioned machinery throughout.

Finish.—To be made normal double breasted as shown by standard sample.

Measurements.

Sizes.	Breast measure- ment.	Length of sleeves.	Length of shirt.	Weight. ¹
	Inches.	Inches.	Inches.	
1.....	36	19	30 $\frac{1}{2}$	13
2.....	38	19 $\frac{1}{2}$	31	14
3.....	40	20	31 $\frac{1}{2}$	15
4.....	42	20 $\frac{1}{2}$	32 $\frac{1}{2}$	16
5.....	44	21	34	17
6.....	46	21	34 $\frac{1}{2}$	18

¹ Pounds per dozen.

Measurements and weights to be approximately as above.

NOTE.—All articles delivered under these specifications are to be like and equal to the standard sample in all respects. The contracting officer is permitted to waive slight defects in the inspection, or to permit slight modifications of the specifications, if, in his discretion, the same do not impair the serviceability or durability of the article.

Samples of the various materials entering into the manufacture of any of the above articles are to be furnished to the contracting officer when desired.

J. B. ALESHIRE,
Chief, Quartermaster Corps.

WAR DEPARTMENT,

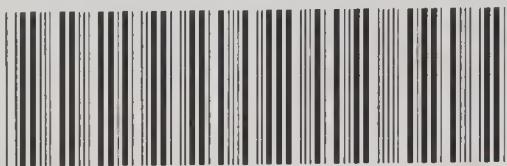
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